

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009013**Date Inspected:** 12-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 2 East)

This QA inspector performed dimensional check and visual testing on cope hole and weld access for OBG lift 2 East and found below locations still required smooth contour finish. Noted comments in ABF inspection report no: CWAHIR-2E-02 and forwarded to lead inspector for further action.

Locations required smooth contour finish:

PP18E- location E4, FB – SP

PP16E- location E3, FB – BP

PP13E- location E4, FB – SP/LD

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (CB4)

FCAW Process:

Welding of weld joint –166 located on PCMK SP209-001. Welder is identified as 220063

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2131.

FCAW Process:

Welding of weld joint –219 located on PCMK SP209-001. Welder is identified as 220064
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2134.

OBG # TRIAL ASSEMBLY YARD- (5BE)

FCAW Process:

Welding of weld joint –006 located on PCMK SEG024B. Welder is identified as 053609
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F)-Repair-1.

FCAW Process:

Welding of weld joint –024 located on PCMK SEG024B. Welder is identified as 053609
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
